

Work Order ID 106515

Thursday, September 05, 2013 10:12:15 AM

106515

RUSH

Page 1

Item ID: D4004-3
Revision ID:
Item Name: Strut Lock Bracket

**D4004-3
B 106515**

Accept

N9000040100

Setup Start ***NS1***
Stop ***NS2***

Start Date: 9/5/2013 Start Qty: 12.00 ***12***
Required Date: 9/10/2013 Req'd Qty: 12.00 ***12***

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr Revision Nbr

D4004

B

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg (D4004-3)

Dwg Rev: **B**

Prog Rev: **B**

2-Deburr if necessary

GRAIN DIRECTION! ✓

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12 0

JmB09-6

12 0

JmB09-6

2024-063

1000
1000

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Item ID: D4004-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Strut Lock Bracket

Start Date: 9/5/2013 Start Qty: 12.00

12

Cust Item ID:

Required Date: 9/10/2013 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

DAS
27
9-89

12

Quality Control

139.6

130

Bend as per dwg

0.00

130

Brake NC

Memo

0.00

12

Brake NC

SA
13/09/04

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

DAS
27
9-89

139.6

Quality Control

12

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Item ID: D4004-3

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N900040100Setup Start ***NS1***

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Stop ***NS2***

Item Name: Strut Lock Bracket

Start Date: 9/5/2013 Start Qty: 12.00

12

Cust Item ID:

Required Date: 9/10/2013 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

12 7613-96

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

DAS
27
9-89DAS
27
9-89

13 9 6

12

170

Identify as per dwg & Stock Location: GA

0.00

170

Packaging

Memo

0.00

Packaging

12

S
13/6 9/09

120
121
122

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Page 4

Item ID: D4004-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Strut Lock Bracket

Start Date: 9/5/2013 Start Qty: 12.00

12

Cust Item ID:

Required Date: 9/10/2013 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

13/9/9 

13-099

Picklist Print

Thursday, September 05, 2013 10:12:14 A

Page 1

Work Order ID: 106515
 Parent Item: D4004-3
 Parent Item Name: Strut Lock Bracket

Start Date: 9/5/2013 Required Date: 9/10/2013
 Start Qty: 12.00 Required Qty: 12.00

Comments: IPP rev A 09.12.15 new issue Prelim EC verified by:DD IPP Rev:B 10.05.17 as per ECN10-562 DD verf:EC IPP Rev:C 12.03.07 as per dwg rev.b DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063 2024-T3 .063 sheet		Purchased	No			100	sf	411.6789	0.024	0.203 0.579			

jm309-6

Location	Loc Qty	Loc Code
MAT022	411.6789	
119916	0.2	
121197	21.34	
123096	11.4	
123654	11.64	
123701	32.7039	
125341	89.44	
125636	244.955	

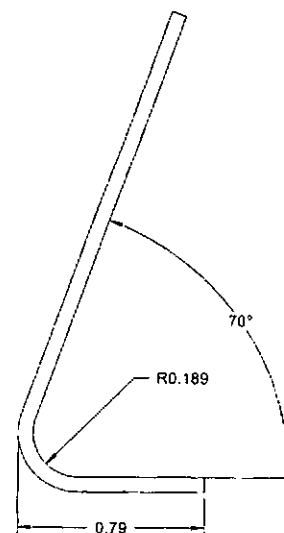
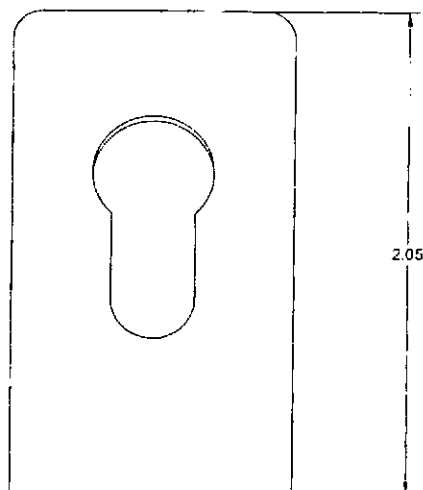
125636

DART AEROSPACE
PART NUMBER

D4004-3

JOHN CAMERON AVIATION
PART NUMBER

REF JCA-M47-2-18



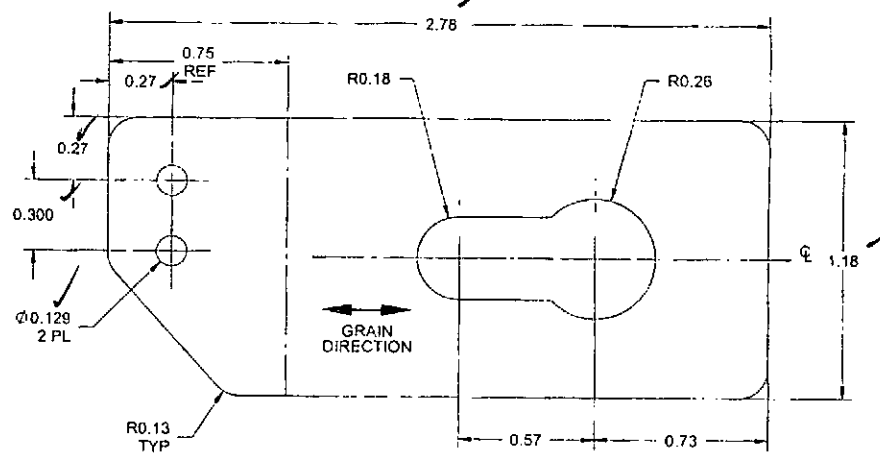
D4004-3 STRUT LOCK BRACKET

RELEASED
2012-03-02
MP

NOTES:

- 1) MATERIAL: MADE FROM D4004-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

DESIGN	BC	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO	REV. B
MFG. APPR.	BC	D4004	SHEET 5 OF 11
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	SIDE RESTRAINT	NTS
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D4004-3F FLAT PATTERN

RELEASED
2012-03-02

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
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